

■ Series 450280 • Coated • Carbide-Tipped • Straight Flute • Grade K10F-DCFD™ • Metric

Material Group								
		Cutting Speed – vc Range – m/min			Recommended Feed Rate per Rev			
		min		max	Tool Diameter	12,70–15,00	15,00–20,00	20,00–32,00
P	1	110	–	130	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	2	110	–	130	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	3	100	–	120	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	4	60	–	80	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	5	30	–	50	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	6	30	–	40	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
M	1	30	–	40	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
	2	30	–	40	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
	3	20	–	30	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
K	1	80	–	100	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	2	80	–	100	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	3	70	–	90	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
S	1	30	–	40	mm/r	0,30–0,50	0,30–0,60	0,35–0,65
	2	20	–	30	mm/r	0,30–0,50	0,30–0,60	0,35–0,65

HSR™ Application Data • Series 456680

■ Series 456680 • Cermet-Tipped • Straight Flute • Grade CERMET-DCFD™ • Metric

Material Group							
		Cutting Speed – vc Range – m/min			Recommended Feed Rate per Rev		
		min		max	Tool Diameter	12,70–15,00	15,00–20,00
P	1	110	–	130	mm/r	0,50–0,90	0,60–1,05
	2	110	–	130	mm/r	0,50–0,90	0,60–1,05
	3	100	–	120	mm/r	0,50–0,90	0,60–1,05
	4	60	–	80	mm/r	0,50–0,90	0,60–1,05
	5	30	–	50	mm/r	0,50–0,90	0,60–1,05
	6	30	–	40	mm/r	0,35–0,65	0,40–0,80